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006153.

D130-1046-111
Job Sheet 184490



Part No: D130-1046-111

Job Qty: 1 ea

Part Name: EC130/H130 Cable Cutter Upper Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D130-1046-111 REV.B IPP REV:A 18.04.26 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.22 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 29 2018
110	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1-5		OCT 29 2018
120	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC4		NOV 06 2018
130	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-2		NOV 12 2018
135	DC	1 pcs	10/26/18	10/26/18	0.00	0.00	DC		NOV 12 2018
140	QC21-FG	1 Ea	10/26/18	10/26/18	0.00	0.00	QC21		NOV 12 2018

Part Op 130 - Identify and pack for shipping as per PPP D130-1046-111 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP D130-1046-111 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5556-041	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125718
D5605-1	Spacer	2 Ea (2 ea)	90-Start up Operation	5053108
D5631-1	Spacer	2 Ea (2 ea)	90-Start up Operation	5120000
LN9016-06K	Washer	6 pcs (6 ea)	90-Start up Operation	FM138453
LN9025-0610K	Washer	2 pcs (2 ea)	90-Start up Operation	5060118
LN9025-0620K	Washer	2 pcs (2 ea)	90-Start up Operation	5053667
LN9037-06075	Bolt	2 pcs (2 ea)	90-Start up Operation	5052523
LN9338-06	Nut	2 pcs (2 ea)	90-Start up Operation	5053675
LN9386-06018A	Bolt, Titanium	6 pcs (6 ea)	90-Start up Operation	5052520

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5556-041	1	1	0
	D5605-1	2	22	0
	D5631-1	2	2	0
	LN9016-06K	6	47	0
	LN9025-0610K	2	6	0
	LN9025-0620K	2	8	0
	LN9037-06075	2	6	0
	LN9338-06	2	8	0
	LN9386-06018A	6	18	0

WORK ORDER NON-CONFORMANCE / UPDATE



Doc: _____ Date: _____

Q. Used: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSIO42) Approval		
Description Work Order Deviation				Disposition				Completed By Supervisor Signature Inspector Signature Material Signature Part Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6L 1K7 CANADA 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss, ☐				Turning Sequence ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Progr. ☐					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock ☐					
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequ ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/Off center ☐					
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Part Specifications

Specifications could not be found.

Plex 10/10/18 1:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REFERENCE ONLY

ITEM	QTY -111	P/N	DESCRIPTION	MANUFACTURER	ALTERNATE PART
	X	D130-1046-111	REMOVABLE PROVISIONS, UPPER		
1	1	D5556-041	CUTTER ASSEMBLY, UPPER		
2	2	D5605-1	SPACER		
3	2	D5631-1	SPACER		
4	6	LN9016-06K	WASHER, BEVELLED (M6)		
5	2	LN9025-0610K	WASHER (M6)		
6	2	LN9025-0620K	WASHER (M6)		
7	2	LN9037-06075	HEX HEAD BOLT, (M6)		
8	2	LN9338-06	NUT (M6)		
9	6	LN9386-06018A	BOLT, TITANIUM (M6)		LN9386-06018
10	A/R	PR1422	SEALANT	PPG/DESOTO	P/S890 OR MIL-S-8802 COMPLIANT
11	A/R	NYCOTE 7-11BL	PROTECTIVE COATING	NYCOTE	
12	A/R	PENETROX A13	ELECTRICAL JOINT COMPOUND	BURNDY	

2

2

2

REFERENCE ONLY

NOTES:

- 1) ALL DIMENSIONS IN MILLIMETERS.
- 2) NOT INCLUDED IN KIT. TO BE PROVIDED BY INSTALLER.
- 3) APPLY SEALANT (ITEM 10) TO CUTTER ASSEMBLY FAYING SURFACES UPON INSTALL.
- 4) WET INSTALL FASTENERS WITH SEALANT (ITEM 10).
- 5) DOME SEAL NUTS WITH SEALANT (ITEM 10).
- 6) FILLET SEAL AROUND CUTTER ASSEMBLY WITH SEALANT (ITEM 10).
- 7) FILLET SEAL AROUND FASTENER HEADS WITH SEALANT (ITEM 10).
- 8) REMOVE TOP FIBERGLASS LAYER TO BONDING STRIP BELOW. REMOVE NON-CONDUCTIVE COATING ON MATING SURFACE OF CUTTER ASSEMBLY, UPPER TO $\phi 18\text{mm}$. ASSEMBLE WITH ELECTRICAL JOINT COMPOUND (ITEM 12).
- 9) CONTACT AREA TO BE CLEAN OF ALL NON-CONDUCTIVE COAT ($\phi 8\text{mm}$).
AFTER ASSY, BARE METAL SURFACES TO BE PROTECTED WITH SEALANT (ITEM 10).
- 10) TRIM TIP FACE FLUSH WITH BOTTOM OF COUNTERBORE IN CUTTER ASSEMBLY, UPPER.
- 11) THIS VIEW FOR USE WITH REMOVAL INSTRUCTIONS, CHAPTER 25 OF ICA-D130-1046, OR WHEN INSTALLING FIXED PROVISIONS FOR LATER USE (WITHOUT THE CUTTER ASSEMBLY INSTALLED).
- 12) IF FIXED ROOF PROVISIONS ARE ALREADY INSTALLED, TRANSFER DRILL $\phi 8.8\text{mm}$ (2 PL) AND $\phi 6.2\text{mm}$ (6 PL) FROM ROOF INSERTS TO CUTTER ASSEMBLY (ITEM 1). OTHERWISE, DRILL CUTTER ASSEMBLY (ITEM 1) $\phi 8.8\text{mm}$ (2 PL) AND $\phi 6.2\text{mm}$ (6 PL) USING DIMENSIONS ON SHEET 2.

B	ADD NOTE 12 & DIMS ON SHEET 2. CUTTER ASSEMBLY HOLES NOW DRILLED ON INSTALL.	CP	18.06.26
A	NEW ISSUE	AJS	18.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JMH	DART AEROSPACE USA, INC.	
DRAWN	CP	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	D130-1046-111	SHEET 1 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	CP	REMOVABLE PROVISIONS, UPPER	NTS
DATE	18.06.26	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

REFERENCE ONLY

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Change Record

PAGE 1 OF 1

Part Number: D130-1046-111

Description: Removable Provisions , Upper

[illegible]

